

DETERMINING THE PERCENTAGE OF FRACTURE IN COARSE AGGREGATE FOP FOR AASHTO TP 61

Scope

This procedure covers the determination of the percentage, by mass, of a coarse aggregate (CA) sample that consists of fractured particles meeting specified requirements in accordance with AASHTO TP 61.

In this procedure, a sample of aggregate is screened on the sieve separating CA and fine aggregate (FA). This sieve will be identified in the agency's specifications, but might be the 4.75 mm (No. 4) sieve. CA particles are visually evaluated to determine conformance to the specified fracture. The percentage of conforming particles, by mass, is calculated for comparison to the specifications.

Apparatus

- Balance or scale: Capacity sufficient for the principle sample mass, accurate to 0.1 percent of the sample mass or readable to 0.1 g. Meets the requirements of AASHTO M231
- Sieves, meeting requirements of AASHTO M 92.
- Splitter, meeting the requirements of AASHTO T 248.

Terminology

1. Fractured Face – An angular, rough, or broken surface of an aggregate particle created by crushing or by other means. A face is considered a “Fractured Face” whenever one-half or more of the projected area, when viewed normal to that face, is fractured with sharp and well defined edges. This excludes small nicks.
2. Fractured particle – A particle of aggregate having at least the minimum number of fractured faces specified. (This is usually one or two.)

Sampling and Sample Preparation

1. Sample and reduce the aggregate in accordance with AASHTO T 2 and AASHTO T 248.
2. When the specifications list only a total fracture percentage, the sample shall be prepared in accordance with Method 1. When the specifications require that the fracture be counted and reported on each sieve, the sample shall be prepared in accordance with Method 2.
3. Method 1 - Combined Fracture Determination
 - a. Dry the sample sufficiently to obtain a clean separation of FA and CA material in the sieving operation.

- b. Sieve the sample in accordance with AASHTO T27/ T11 over the 4.75 mm (No. 4) sieve, or the appropriate sieve listed in the agency's specifications for this material.

Note 1: Where necessary wash the sample over the sieve or sieves designated for the determination of fractured particles to remove any remaining fine material, and dry to a constant mass in accordance with AASHTO T 255.

- c. Reduce the sample using Method A, Mechanical Splitter, in accordance with AASHTO T248 to the appropriate test size. This test size should be slightly larger than shown in Table 1, to account for loss of fines through washing, if necessary.

TABLE 1
Sample Size
Method 1 (Combined Sieve Fracture)

Nominal Maximum Size* mm (in.)	Minimum Sample Mass Retained on 4.75 mm (No. 4) Sieve g (lb)
37.5 (1 1/2)	2500 (6)
25.0 (1)	1500 (3.5)
19.0 (3/4)	1000 (2.5)
12.5 (1/2)	700 (1.5)
9.5 (3/8)	400 (0.9)
4.75 (No. 4)	200 (0.4)

* One sieve larger than the first sieve to retain more than 10 percent of the material, using specification sieves. See complete definition on page 18.

4. Method 2 – Individual Sieve Fracture Determination

- a. Dry the sample sufficiently to obtain a clean separation of FA and CA material in the sieving operation. A washed sample from the gradation determination may be used.
- b. If not, sieve the sample in accordance with AASHTO T 27 over the sieves listed in the specifications for this material.

Note 2: If overload (buffer) sieves are used the material from that sieve must be added to the next specification sieve.

- c. Select a representative portion from each sieve by splitting or quartering in accordance with AASHTO T 248. The size of test sample for each sieve should be at least as large as shown in Table 2.

Note 1: Where necessary wash the sample over the sieve or sieves designated for the determination of fractured particles to remove any remaining fine material, and dry to a constant mass in accordance with AASHTO T 255.

TABLE 2
Sample Size
Method 2 (Individual Sieve Fracture)

Sieve Size mm (in.)		Minimum Sample Mass g (lb)	
31.5	(1 1/4)	1500	(3.5)
25.0	(1)	1000	(2.2)
19.0	(3/4)	700	(1.5)
16.0	(5/8)	500	(1.0)
12.5	(1/2)	300	(0.7)
9.5	(3/8)	200	(0.5)
6.3	(1/4)	100	(0.2)
4.75	(No. 4)	100	(0.2)
2.36	(No. 8)	25	(0.1)
2.00	(No. 10)	25	(0.1)

Note 3: If fracture is determined on a sample obtained for gradation, use the mass retained on the individual sieves. If less than 5 percent of the total mass is retained on a single specification sieve, include that material on the next smaller specification sieve.

Procedure

1. Where necessary, wash the sample over the sieve or sieves designated to remove any remaining fine material, and dry to a constant mass in accordance with AASHTO T 255.
2. After cooling, spread the dried sample on a clean, flat surface large enough to permit careful inspection of each particle. To verify that a particle meets the fracture criteria, hold the aggregate particle so that the face is viewed directly.
3. To aid in making the fracture determination separate the sample into three categories:
 - fractured particles meeting the criteria
 - particles not meeting the criteria
 - questionable or borderline particles
4. Determine the dry mass of particles in each category to the nearest 0.1 g.

Note 4: If, on any determination, more than 15 percent of the total mass of the sample is placed in the questionable category, repeat the procedure until no more than 15 percent is present in that category.

Calculation

Calculate the mass percentage of fractured faces to the nearest 1 percent using the following formula:

$$P = [(F + Q/2)/(F+Q+N)] \times 100$$

where: P = Percent of fracture
F = Mass of fractured particles
Q = Mass of questionable or borderline particles.
N = Mass of unfractured particles

Example:

$$F = 632.6 \text{ g}, \quad Q = 97.6 \text{ g}, \quad N = 352.3 \text{ g}$$

$$P = [(632.6 \text{ g} + 97.6 \text{ g}/2) / (632.6 \text{ g} + 97.6 \text{ g} + 352.3 \text{ g})] \times 100 = 63 \%$$

Report

Results shall be reported on standard forms approved for use by the agency. Report fracture to the nearest 1 percent.